

# Work Order ID 52451

September 25, 2009 7:08:45 AM



Page 1

Item ID: D3552-7

Accept



Setup Start



Revision ID: D

Stop



Item Name: Door Prop

Start Date: 9/25/09 Start Qty: 12.00



Cust Item ID:

Required Date: 9/30/09 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: *CZ*

Date: *09/09/25*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3552

Rev D

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: *10462* Purchase Part Number: B6-220-530-70N Supplier: LS Technologies Certificate of conformity is required

*CZ 09/09/25 (12)*

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

*Pc 9/14/02 (12)*

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Test for correct pressure

*27 80710/07*

*(12) 9*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 52451

September 25, 2009 7:08:45 AM



Page 2

Item ID: D3552-7

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Setup Start



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Item Name: Door Prop

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Cust Item ID:

Required Date: 9/30/09 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: St 272

0.00

UMP 09/10/08

x/2



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/08

W 09.10.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

September 25, 2009 7:08:45 AM

Work Order ID: 52451

Parent Item: D3552-7RevD

Parent Item Name: Door Prop

Comments:



Start Date: 9/25/09

Start Qty: 12.00

Required Date: 9/30/09

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
B6-220-530-070N		Purchased	No				Each	0.0000	12.0000			
CARBON STEEL GAS SPRING												

9/10/09 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

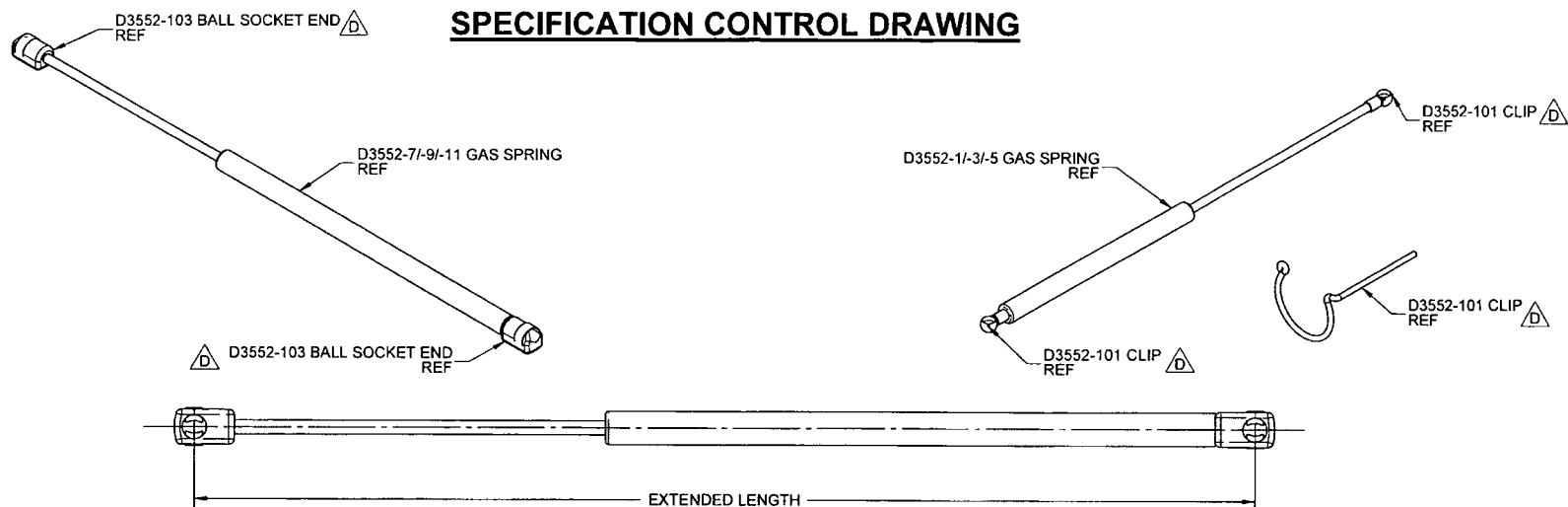
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# SPECIFICATION CONTROL DRAWING



## D3552-X GAS SPRING

DART PART NUMBER	DESCRIPTION	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	FORCE (N/lb)	END FITTING	MATERIAL	SUPPLIER	SUPPLIER PART NUMBER
D3552-1	GAS SPRING	220/8.66	530/20.6	70/15.7	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-220-530-070N
D3552-3	GAS SPRING	200/7.87	490/19.3	200/45.0	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-200-490-200N
D3552-5	GAS SPRING	175/6.89	430/16.9	150/33.7	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-175-430-150N
D3552-7	GAS SPRING	220/8.66	530/20.9	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-220-530-070N
D3552-9	GAS SPRING	200/7.87	490/19.3	200/45.0	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-200-490-200N
D3552-11	GAS SPRING	240/9.45	575/22.6	150/33.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-240-575-150N
D3552-101	CLIP	N/A	N/A	N/A	N/A	CARBON STEEL	LS TECHNOLOGIES	C9
D3552-103	BALL SOCKET END	N/A	N/A	N/A	N/A	NYLON	LS TECHNOLOGIES	B10

RELEASED  
06/15/10

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 53451  
08/09/10/07

### NOTES:

- IDENTIFICATION: IDENTIFY WITH DART P/N "D3552-X" AND B/N USING WHITE FINE POINT PERMANENT INK MARKER
- D3552-101 CLIP IS ONLY COMPATIBLE WITH D3552-1/-3/-5 GAS SPRINGS
- D3552-103 BALL SOCKET END IS ONLY COMPATIBLE WITH D3552-7/-9/-11 GAS SPRINGS

D	ADD P/N D3552-101 ZN D6-1, C7-1, C1-1 AND D3552-103 ZN D1-1 AND C2-1 AND ZN B8-1; ADD NOTE REGARDING D3552-101 AND D3552-103 COMPATIBILITY ZN A8-1	09.04.02
C	ADD D3552-11 AND CONVERSIONS FOR INSPECTION; UPDATE P/N FOR D3552-7	07.05.01
B	ADD D3552-7/-9; UPDATE DESC. D3552-1/-3/-5	06.10.24
A	NEW ISSUE	06.09.15
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.	CL	
APPROVED		
DE APPR.		
DATE	09.04.02	

DART AEROSPACE LTD  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D3552

REV. D

SHEET 1 OF 1

TITLE

GAS SPRING

SCALE

NTS

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LS Technologies Canada Inc.

303 - 103 Street  
Saskatoon, SK Canada  
S7N 1Y9

# Packing Slip

P.O. No.	Date	Packing Slip #
10462	9/25/2009	5383

Name / Address
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7 Canada

Ship To
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7 Canada

Rep	Ship Date	Ship Via
Nolan	9/25/2009	Purolator

Qty	Description
12	B6-220-530-070N Carbon Steel Gas Spring  Shipping via PUROLATOR Collect - Tracking # 329135014812  Total GST Business Number: 875007718





303 – 103<sup>rd</sup> Street, Saskatoon, Saskatchewan, Canada S7N 1Y9

Ph: (306) 683-5000 Fax: (306) 683-6403

E-mail: [lstech@lsttechnologies.ca](mailto:lstech@lsttechnologies.ca) [www.liftsupporttechnologies.com](http://www.liftsupporttechnologies.com)

## Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.

12Units: B6-220-530-070N Carbon Steel Gas Spring

Country of Manufacture: Canada

Date of Manufacture : 2009

This product is ROHS compliant.

802/10/07

We certify no mercury was used in the manufacture of this order.

Purchase Order # 10462

Invoice # 5383

L S Technologies Inc Canada

A handwritten signature in black ink, appearing to read "Nolan Fehr", written over a horizontal line.

Nolan Fehr  
Manager



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO10462**

Purchase Order Date 9/25/09

PO Print Date 9/25/09

Page Number 1 of 1

Order From :

VC-LST0001

LS TECHNOLOGIES INC.  
303-103 STREET  
SASKATOON, SK S7N 1Y9  
CA

**FAXED**  
667/613

Contact Name

Vendor Phone 306 683 5000

Vendor Fax 306 683 6403

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	B6-220-530-070N	CARBON STEEL GAS SPRING	9/30/09 Yes	12.00 Each	Purolator ground	\$36.8500	\$442.20

Special Inst: AS PER DWG D3552 REV. D  
B52451  
LS TECHNOLOGIES P/N:  
B6-220-530-70N

PO Total:

\$442.20

CERTIFICATE OF CONFORMITY  
REQ'D UPON DELIVERY

Change Nbr: 1

Change Date: 9/25/09

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

